

Date: Monday, 7/30/2007 1:52:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
 Job Number : 33780
 Estimate Number : 12923
 P.O. Number : N/A Part Number : D2659UP
 This Issue : 7/30/2007 S.O. No. : N/A Drawing Number : D2659 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 8/12/2007 Qty: 14 Um: Each
 Checked & Approved By : 07.07.30
 Comment : Est Rev A New Issue 07-07-04 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 33780A LUG



Comment: Sub-Component LUG
 D2657 B 32654

2.0 33780B LUG BRACKET



Comment: Sub-Component LUG BRACKET
 D2658 B 33780 B

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484
 A/RSteel Rod 1403794

07/09/05

14

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/06

14

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/06

14

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

07-09-06

14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:52:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 33780

Part Number: D2659UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

W 27-09-06

Job Completion



W 27-09-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

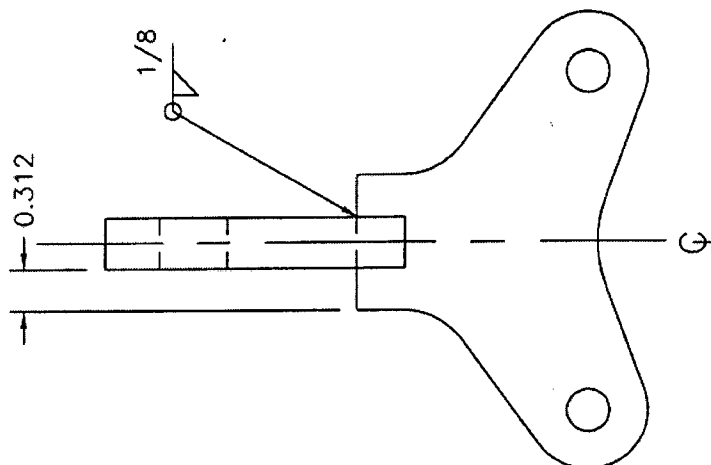
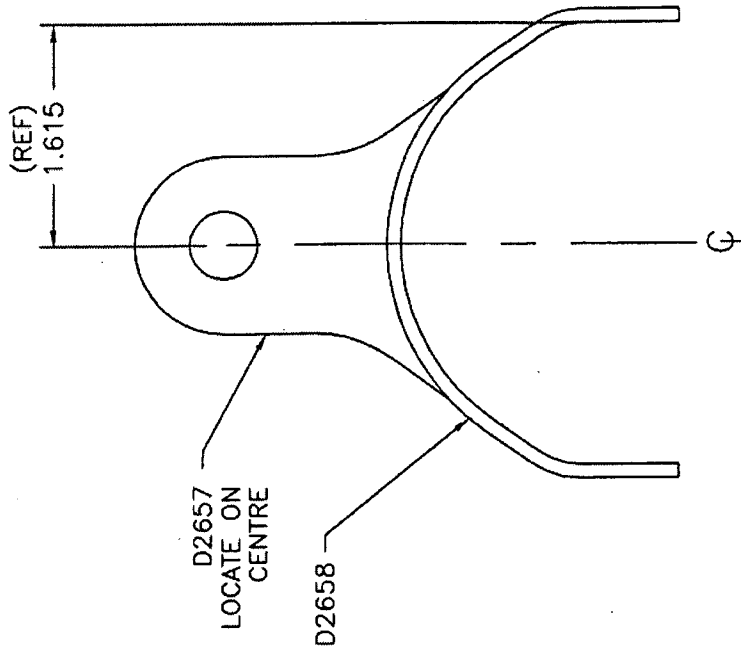
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>MS</i>	DRAWN BY <i>MS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>S</i>	APPROVED <i>MS</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03	TITLE LUG ASSEMBLY		SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

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WITHOUT NOTICE
WORK ORDER
NO. 33780

Date: Monday, 7/30/2007 1:52:28 PM
 User: Kim Johnston

Process Sheet

②

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 33780B	
Estimate Number : 10339	
P.O. Number : N/A	Part Number : D2658
This Issue : 7/30/2007 S.O. No. : N/A	Drawing Number : D2658 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : D
Previous Run : 32376B	Material : N/A
Written By : <u>AD 07.07.31</u>	Due Date : 8/12/2007 Qty: 12 Um: Each
Checked & Approved By : <u>AD 07.07.31</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-08-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.1197 sf(s)/Unit Total : 1.4364 sf(s)
 1010/1025/A21/6aA SHEET
 12 GAUGE .100" THK
 Batch: M101094 IB07-08-05

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2858
 Dwg Rev: D
 Prog Rev: D

IB 07-08-05

2-Deburr if necessary

SAD 07/08/09

①②

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/08/07

contp

④①⑥

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr as required.

SAD 07/08/09

①⑥

2-Bend on CNC brake using DT8254 Identify as D2658

SAD 07/08/15 ①⑤

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/15	2.0	one part - sensor holes are old. R.C. Part moved during water jetting	<u>SB</u> <u>07/08/15</u>	Scrap and destroy no replace	<u>SB</u> <u>07/08/15</u>	<u>En</u> <u>07/08/15</u>	<u>SB</u> <u>07/08/15</u>	<u>En</u> <u>07/08/15</u>

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:52:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 33780B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/15 (15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: JH

U 8-9-05

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

15

1207/09/06

Job Completion



U 8-9-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

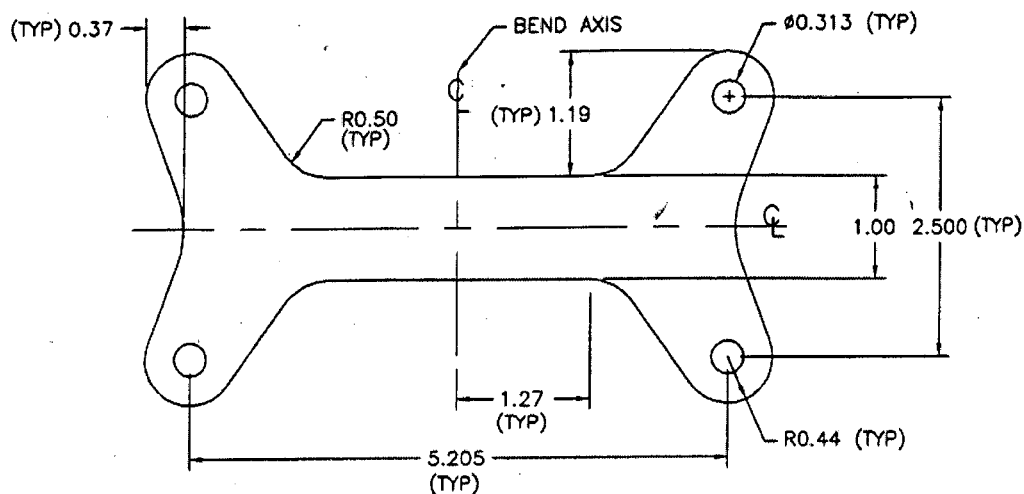
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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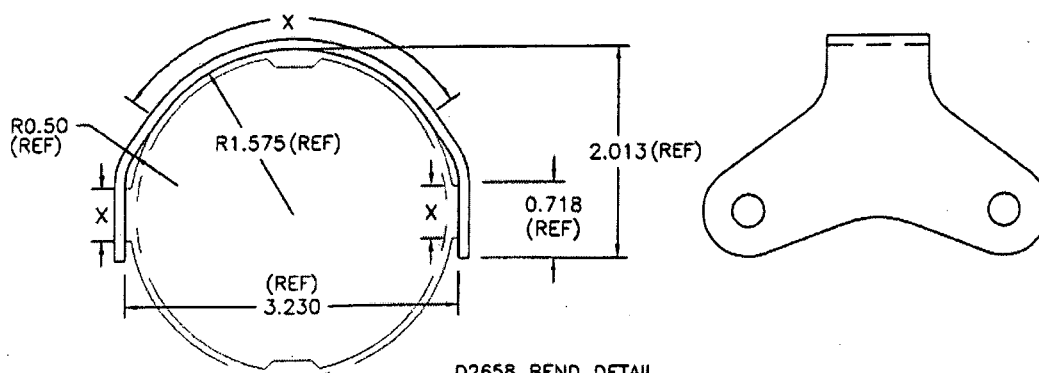


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED LE	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 33780B